

Work Order ID 85333

June-06-12 9:03:11 AM

85333

Page 1

Item ID: D3255-041
Revision ID:
Item Name: Access Panel Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 06/06/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/06 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3255	Rev B
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100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD								
	Batch: <u>M114509</u> 2-Grind Welds Flush								

4

12-06-07

JBL

110	QC10- Inspect visual per QSI004- ground welds	0.00							
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110									
QC	Memo	0.00							

Quality Control

4x

Pl 12-06-07

120	QC5- Inspect part completeness to step on W/O	0.00							
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120									
QC	Memo	0.00							

Quality Control

Erzbecker /

4x

Pl 12-06-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start

NS1

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Item Name: Access Panel Assembly

Stop

NS2

Start Date: 06/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: M122346

4X  12/06/11

4x  12/06/11

4  12-07-11

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Page 3

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Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____
 QC: _____ Date: _____ SPC (Y/N): _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O 0.00

160

QC

Memo

Quality Control

DAS
16
9-82 7/14/19

(74)

170 Identify as per dwg & Stock Location: St 176 0.00

170

Packaging

Memo

Packaging

0.00

4

12/07/20 JB

180 QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

Quality Control

0.00

12/17/23 JG

ME
12-01-20

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NOTE: Date & initial all entries

Picklist Print

June-06-12 9:03:20 AM

Page 1

Work Order ID: 85333

85333

Parent Item: D3255-041

D3255-041

Parent Item Name: Access Panel Assembly

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1		Manufactured	No	183198 X 41		100	Each	2.0000	1	4			

D3255-1

Panel

**

12-06-06 JLM

Location

Loc Qty

Loc Code

WA025

2

72191

2

D3255-5

Manufactured No

100

Each

16.0000

1

4

D3255-5

Gasket

**

FF 12-06-19

Location

Loc Qty

Loc Code

GA

16

72118

1

75083

1

80183

2

83478

12

D3255-3

Manufactured No

150

Each

10.0000

1

4

D3255-3

Cap

**

12-06-06 JLM

Location

Loc Qty

Loc Code

WA

8

83201

8

WA022

2

75969

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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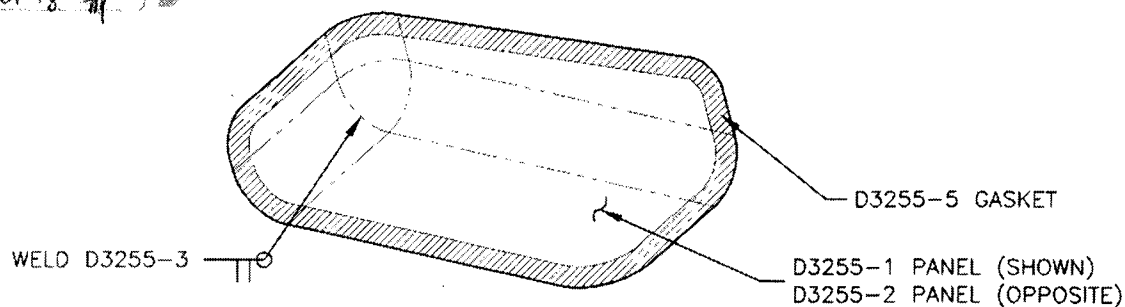
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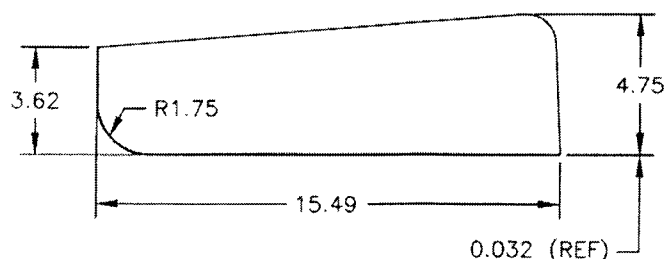
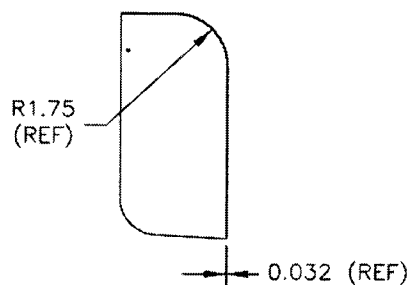
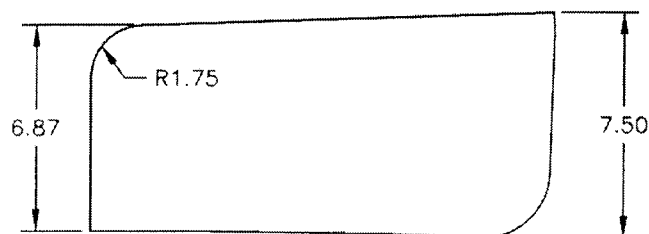


DESIGN 77	DRAWN BY 77	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 10	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85333 MLC
12/06/04

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Dart Aerospace Ltd

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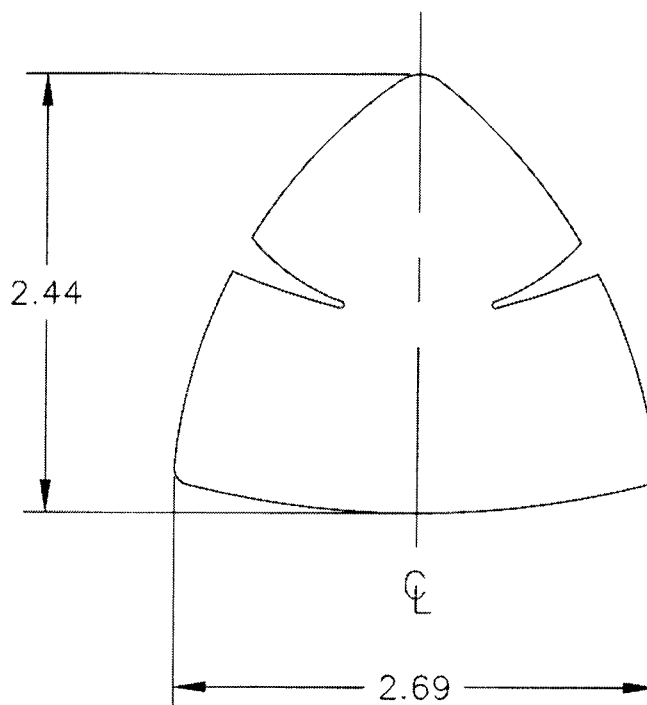
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NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

05333

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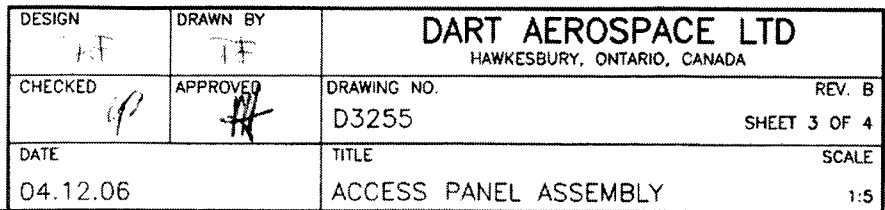
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

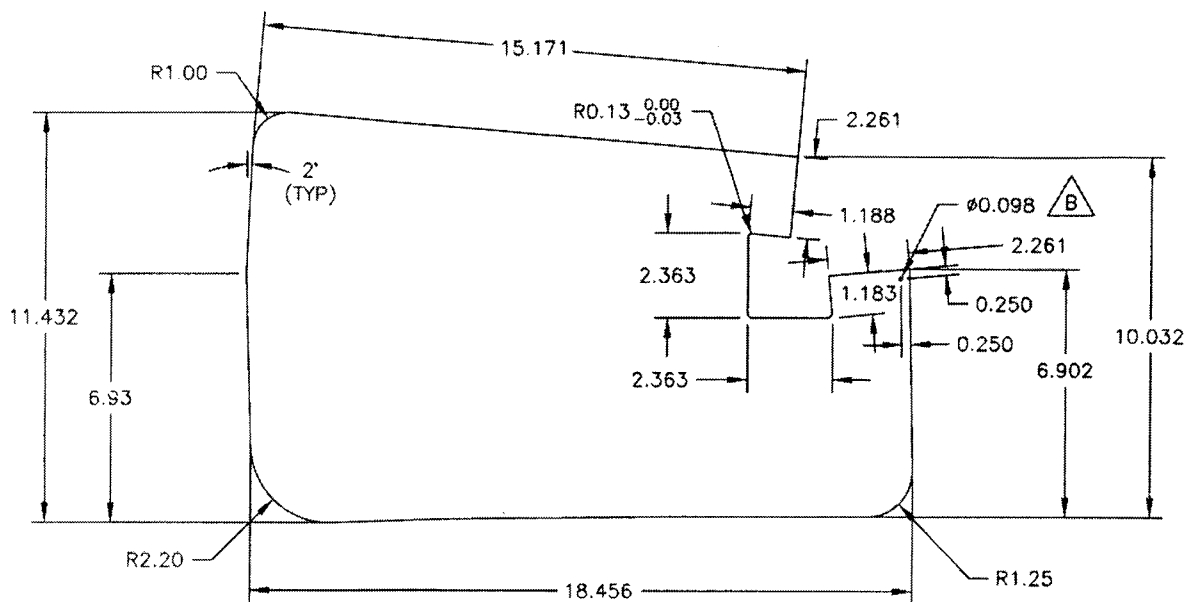
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NOTE: Date & initial all entries



RELEASED
[05-01-18]



D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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4) BREAK ALL SHARP EDGES 0.005 TO 0.010

85333

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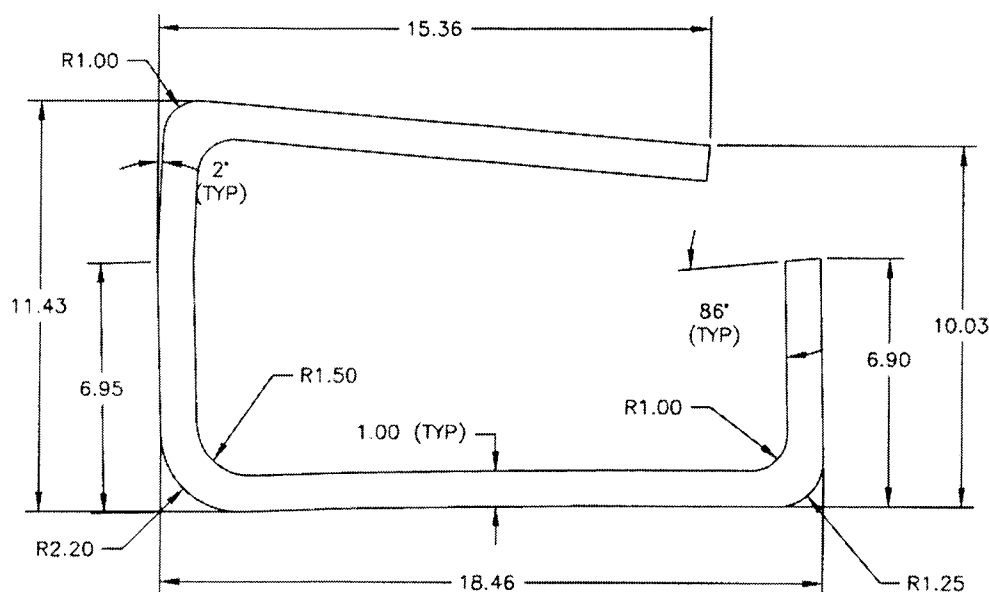
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NOTE: Date & initial all entries



DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01/18 JH



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

05333

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